

Work Order ID 130182

130182

Page 1

February-26-15 9:22:34 AM

Item ID: D350-600-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9639	A								
DSI9701	A								
IIN-D350-600	E								

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile &type labels per PPP D350-600-241
CHG 002

1x

DAS

46

9-29

APR 29 2015

110

110

Small Fab

Small Fab

Memo

0.00

1-Drill holes in D3188-1 using drill jig Dt8970
2-Open holes in D3188-1body floor to 0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per dwg D3188

15-03-01

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: dot Date: 15/05/08

QA Closed: dot Date: 15/05/06

Work Order: <u>130182</u> Part No. <u>D350-600-241</u> NCR No. <u>15-4887</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☒ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
---	--	---

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	15-03-09	110	x3	AN526C832R24 screws too short in 3 locations thickness variation in composite part RL material Build up on composite	DAS 16 9-89 205/03/09 02042	use AN526C832R24 screws B 130835 x3	15-03-09	DAS 9 9-89 15-03-09	DAS 16 9-89 205/03/09 02042
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☒ Other

composite Build up

Work Order ID 130182

February-26-15 9:22:34 AM

130182

Page 2

Item ID: D350-600-241 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod™ Fwd Opening LH AS 350
 Start Date: 2/26/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

150		0.00							
150									
Small Fab	Memo	0.00							15-03-01
Small Fab	Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600 ***Hardware on previous steps is for door ass'y*** 1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with milled glass fibres 10% to weight A/R Hysol batch: 131581 xpiry date: 15-12-17 A/R Milled fibers batch: 100859 2-Attach Neoprene Foam using Contact cement A/R Contact cement Batch: 100859								

N/A
 Foam already
 installed
 as per B 59334

Work Order ID 130182

February-26-15 9:22:34 AM

130182

Page 3

Item ID: D350-600-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacepod™ Fwd Opening LH AS 350

Stop

NS2

Start Date: 2/26/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/06/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

1503-09

DAS
9
9-89

170

Wing Walk as per dwg QSI005 4.4 Batch 121659

0.00

170

HandFinish

Memo

0.00

Hand Finishing

15-03-09

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

1503-09

DAS
9
9-89

February-26-15 9:22:34 AM

Page 4

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	Pick Kit	0.00							
185						DAS 27 9-89			
Packaging	Memo	0.00							
Packaging						APR 22 2015			
190	QC4- 100% Inspect kits for completeness	0.00							
190						DAS 66 9-89			
QC	Memo	0.00							
Quality Control						MAY 04 2015			
200	Identify as per dwg & Stock Location: <u>030</u>	0.00							
200									
Packaging	Memo	0.00				DAS 66 9-89			
Packaging	Identify and pack for shipping as per PPP D350-600-241 Location: _____ PPP rev: _____								
						MAY 04 2015			

Work Order ID 130182

February-26-15 9:22:34 AM

130182

Page 5

Item ID: D350-600-241

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacepod™ Fwd Opening LH AS 350

Stop

NS2

Start Date: 2/26/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ

MAY 04 2015

MLJ MAY 04 2015

Picklist Print

February-26-15 9:22:30 AM

Page 1

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A07.03.07 new issue ec
 IPP rev B 07.04.16 reformat,D3188 revE ec IPP Rev:C
 remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D
 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified
 by: DD IPP Rev:E remove seq 130/140 now all in seq
 150 DD 10.05.13 verf
 :EC IPP REV:F
 13.02.06 AS PER DSI9639 REV.A DD VERF:JLM IPP REV:G 14.07.30
 as per DSI9701 rev.a DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-6A *AN3-6A* Bolt	DAS 46 9-89	Purchased	No				Each	236.0000	**	7			DAS 02 9-89
Location ST338a M130466 M131305 ST349 113288 M128739 Loc Qty 200 100 100 36 4 32 Loc Code													
D2985 *D2985* Label	DAS 46 9-89	Manufactured	No				Each	9.0000	**	1			DAS 02 9-89
Location ST014 104987 Loc Qty 9 9 Loc Code													
D2985-1 *D2985-1* Decal, LH Install	DAS 46 9-89	Manufactured	No				Each	9.0000	**	1			DAS 02 9-89
Location ST014 96951 Loc Qty 9 9 Loc Code													

APR 22 2015

Picklist Print

February-26-15 9:22:30 AM

Page 2

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

D3188-5 Manufactured No

110

Each

0.0000

1

1

D3188-5

Spacepod Body

D5127-1

Manufactured No

Each

34.0000

2

D5127-1

Shim, Large

130181

**

BT 15-02-24

**

BT 15-03-02

Location

Loc Qty

Loc Code

ST149

14

125150

4

127406

10

ST155a

20

128839

20

D5127-3

Manufactured No

Each

30.0000

2

D5127-3

Shim, Small

123195

**

BT 15-03-02

Location

Loc Qty

Loc Code

ST149

10

127632

10

ST155a

20

128941

20

D3186-3

Manufactured No

110

Each

0.0000

1

1

D3186-3

Spacepod Door, LH

D3187-1

Manufactured No

110

Each

6.0000

1

1

D3187-1

Floor Panel

130180

**

BT 15-02-24

**

BT 15-03-02

Location

Loc Qty

Loc Code

ST400

6

59334

6

71

DAS
06
9-88

February-26-15 9:22:31 AM

Shop Packet Print

Page 2

Picklist Print

February-26-15 9:22:31 AM

Page 3

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

AELS4-1032-130

Purchased

No

110

Each

2,566.000

28

28

AI S4-1032-130

Rivnut

15-03-07

Location

Loc Qty

Loc Code

CA

1567

M128649

1567

st549

999

110511

10

M128649

989

728

A3235-020-935

Purchased

No

110

Each

155.0000

8

8

A3235-020-935

Washer, Countersunk

15-03-02

Location

Loc Qty

Loc Code

ST548

155

106150

155

78

D2986-1

Manufactured

No

150

Each

4.0000

1

1

D2986-1

Rubber Spacer

N/A already installed as per 359334

Location

Loc Qty

Loc Code

ST518A

4

127615

4

D3015-3

Manufactured

No

150

Each

19.0000

1

1

D3015-3

Locknut

129764

15-03-07

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

1

48238

1

February-26-15 9:22:31 AM

Shop Packet Print

Page 3

Picklist Print

February-26-15 9:22:31 AM

Page 4

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

D3554-7

Manufactured No

150

Each

23.0000

1

1

D3554-7

Ball Stud

ET 15-03-02

Location

Loc Qty

Loc Code

FG

5

87039

5

ST049

18

37674

1

87571

17

D3567-1

Manufactured No

150

Each

2.0000

1

1

D3567-1

Decal

ET 15-03-02

Location

Loc Qty

Loc Code

ST049

2

48254

2

NAS1149D0563J

Purchased No

150

Each

1,253.000

1

1

NAS1149D0563.J

Washer

ET 15-03-02

Location

Loc Qty

Loc Code

GA

130

m125807

130

ST260a

68

113524

3

118206

2

m130799

63

ST269

156

m128257

156

ST271

899

m131026

899

Picklist Print

February-26-15 9:22:31 AM

Page 5

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

D2237 Manufactured No 150 Each 64.0000 2 2

D2237

Striker Plate

15-03-02

Location

Loc Qty

Loc Code

ST005

64

121746

34

128358

30

X2

MS20426AD4-5

Purchased No

150 Each

2,275.000

4

4

MS20426AD4-5

RIVET

15-03-02

Location

Loc Qty

Loc Code

GA

2243

m130922

2243

ST312

32

m125807

32

X4

D3538-1

Manufactured No

150 Each

14.0000

2

2

D3538-1

Hinge Bracket

15-03-02

Location

Loc Qty

Loc Code

FG

6

115602

3

84630

1

98281

2

ST048

8

128374

8

X2

Picklist Print

February-26-15 9:22:32 AM

Page 6

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

D2179 Manufactured No 150 Each 30.0000 2 2

D2179

Hinge Bracket Plate

FT 15-03-02

Location

Loc Qty

Loc Code

ST004

30

106233

24

35432

6

x2

AN526C832R24

Purchased

No

150

Each

86.0000

4

4

AN526C832R24

screw

FT 15-03-02

Location

Loc Qty

Loc Code

ST327

86

118870

20

124255

66

x4

MS27039-08-11

Purchased

No

150

Each

372.0000

2

2

MS27039-08-11

SCREW

FT 15-03-02

Location

Loc Qty

Loc Code

ST282

372

m130358

372

x2

Picklist Print

February-26-15 9:22:32 AM

Page 7

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

150

Each

844.0000

20

20

NAS1149DN832.J

Washer

ET 15-03-02

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST270

575

124555

15

M128429

8

M131317

552

NAS1515H3

Purchased

No

150

Each

75.0000

2

2

NAS1515H3

Washer

ET 15-03-02

Location

Loc Qty

Loc Code

FG

10

123301

10

GA

44

m129521

44

ST266

21

m128635

21

x2

Picklist Print

February-26-15 9:22:32 AM

Page 8

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

150

Each

1,444.000

18

18

MS21042L 08

Nut

15-03-02

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

1343

123900

16

m128401

156

m130325

171

m131317

500

m131624

500

218

D2464

Manufactured

No

150

f

842.0000

11.34

12

D2464

Seal(\$per foot)

110770

15-03-09

Location

Loc Qty

Loc Code

ST638

842

121946

815

83543

27

Picklist Print

February-26-15 9:22:32 AM

Page 9

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

150

Each

109.0000

2

2

D2586

Door Latch

ET 15-07-02

Location

Loc Qty

Loc Code

FG

16

100607

1

114985

5

119746

4

83893

5

95760

1

ST482

48

128416

48

ST488a

45

129404

45

x2

D2585

Manufactured No

150

Each

44.0000

2

2

D2585

Latch Clamp

ET 15-03-02

Location

Loc Qty

Loc Code

ST008

44

127709

44

x2

D2621

Manufactured No

150

Each

46.0000

2

2

D2621

Latch Plate

ET 15-03-02

Location

Loc Qty

Loc Code

FG

2

88616

2

ST008A

20

123542

20

ST012a

24

127749

24

x2

February-26-15 9:22:33 AM

Shop Packet Print

Page 9

Picklist Print

February-26-15 9:22:33 AM

Page 10

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

150

Each

171.0000

2

2

MS27039-1-15

Screw

21 15-03-02

Location

Loc Qty

Loc Code

GA

99

m127916

99

ST285

72

m127916

72

x2

NAS1149D0363J

Purchased

No

150

Each

3,009.000

2

2

NAS1149D0363.J

Washer

21 15-03-02

Location

Loc Qty

Loc Code

CA

569

m130799

569

FP001

14

113288

14

x2

GA

426

m128429

426

ST269

2000

m131618

2000

Picklist Print

February-26-15 9:22:33 AM

Page 11

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,724.000

2

2

MS21042L3

ET 15-03-02

Nut

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

976

M131317

976

ST305

1328

112385

7

113537

15

116549

22

M131264

545

M131624

739

x2

D2857-1

Manufactured

No

150

Each

38.0000

1

1

D2857-1

ET 15-03-02

Hinge Bracket

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST012

9

120387

9

ST012a

24

121829

24

x1

Picklist Print

February-26-15 9:22:33 AM

Page 12

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

D2857-2	Manufactured	No	150	Each	23.0000	1	1
D2857-2							
Hinge Bracket							
						**	15-03-02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	3	
78904	3	
ST012a	20	
114154	20	

D2228	Manufactured	No	150	Each	48.0000	4	4
D2228							
Backing Plate							
						**	15-03-02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST005	19	
95704	19	
ST012a	29	
105984	29	

AN526C832R10	Purchased	No	150	Each	122.0000	10	10
AN526C832R10							
Screw							
						**	15-03-02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST327	122	
123831	22	
m127363	100	

D3557-1	Manufactured	No	150	Each	15.0000	1	1
D3557-1							
Bracket							
						**	15-03-02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST049	15	
125281	2	
126308	10	
73384	3	

February-26-15 9:22:33 AM

Shop Packet Print

Page 12

Picklist Print

February-26-15 9:22:33 AM

Page 13

Work Order ID: 130182

130182

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 2/26/15

Required Date: 3/06/15

Start Qty: 1.00

Required Qty: 1.00

AN526C832R14

Purchased

No

150

Each

121.0000

2

2

AN526C832R14

Screw

ST 15-03-02

Location

Loc Qty

Loc Code

ST327

121

104916

8

124215

105

124916

8

K10021

DAS
06
9-89

Manufactured

No

185

Each

0.0000

1

1

K10021

Spacepod Hardware (-241)

D350-600-449

Manufactured

No

185

Each

0.0000

1

1

D350-600-449

Switch Relocation

DAS
06
9-89

Manufactured

No

185

Each

9.0000

1

1

D2985

Label

129969

ST

128845

ST

SP

Location

Loc Qty

Loc Code

ST014

9

104987

9

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

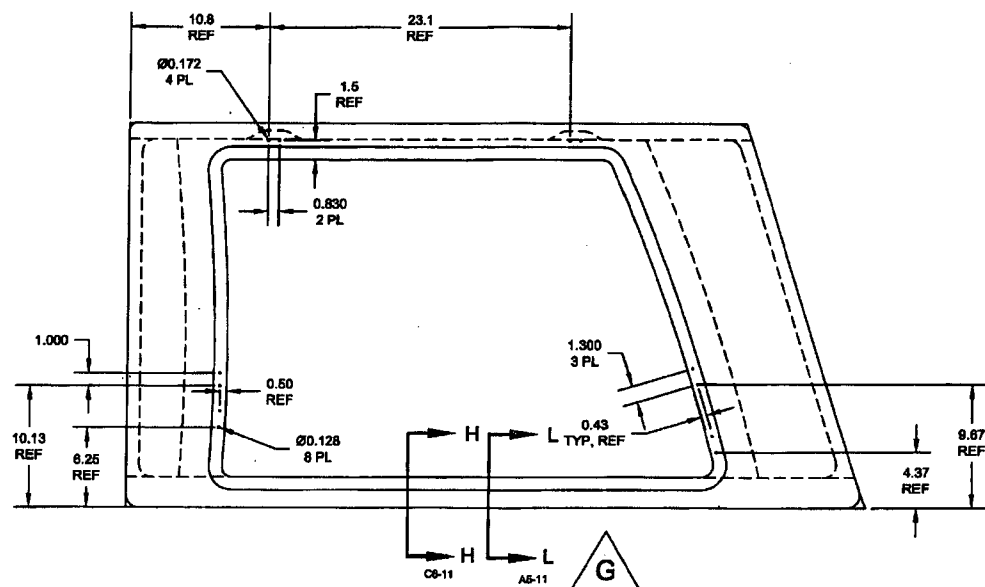
PART	LAYUP	TRIM AND DRILL
D3188-1M-1/-5	DT8003	DT8501
D3188-2M-2/-6	DT8004	DT8502
D3188-3M-3/-7	DT8500	DT8501

- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 008. LAMINATION SCHEDULE PER THIS DRAWING
- 10) POT INSERTS PER QSI 008 SECTION 4.16

also 130182

RELEASED
2014-07-28

G	ADD SECTION K-K/L-L: INSERT INSTALLATION TO SHEET 11 (ZN A5-11)	DB	14.08.20
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	08.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M-2M-3M-6/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JA	DRAWING NO.	REV. G
MFG. APPR.	JA	D3188	SHEET 1 OF 11
APPROVED	JA	TITLE	SCALE
DE APPR.	JA	SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



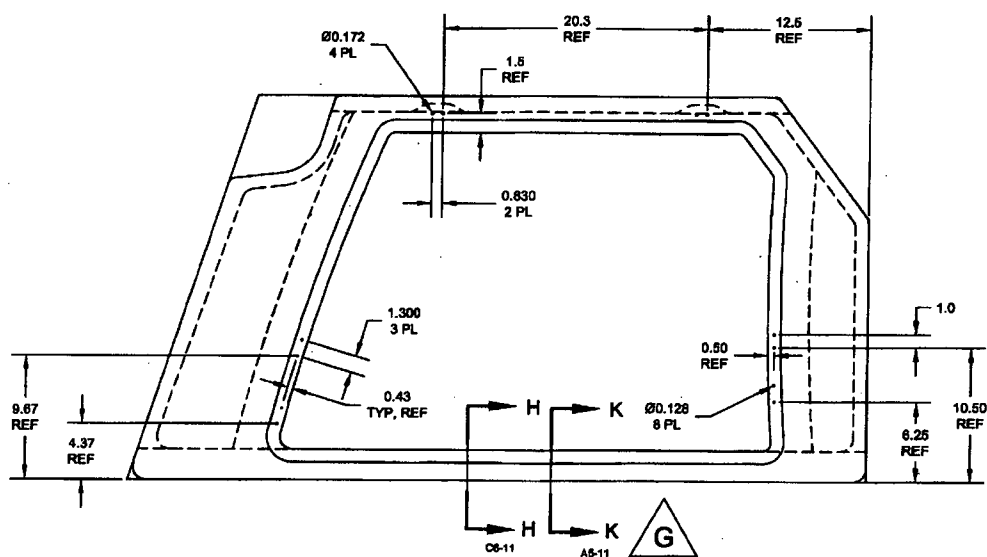
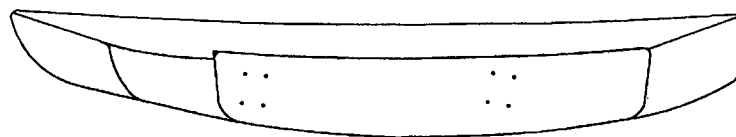
RELEASED
2014-07-28

D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



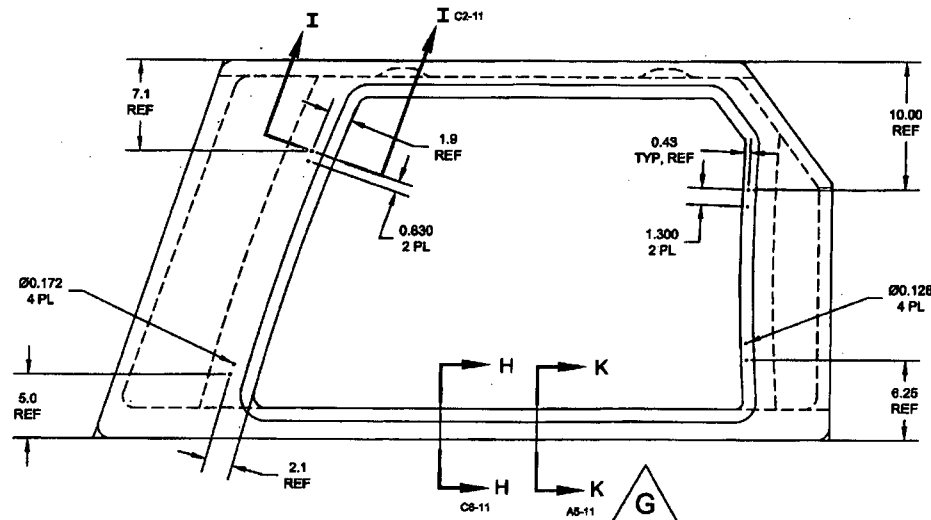
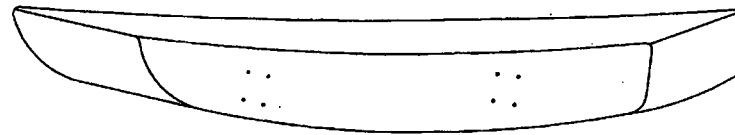
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3188	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



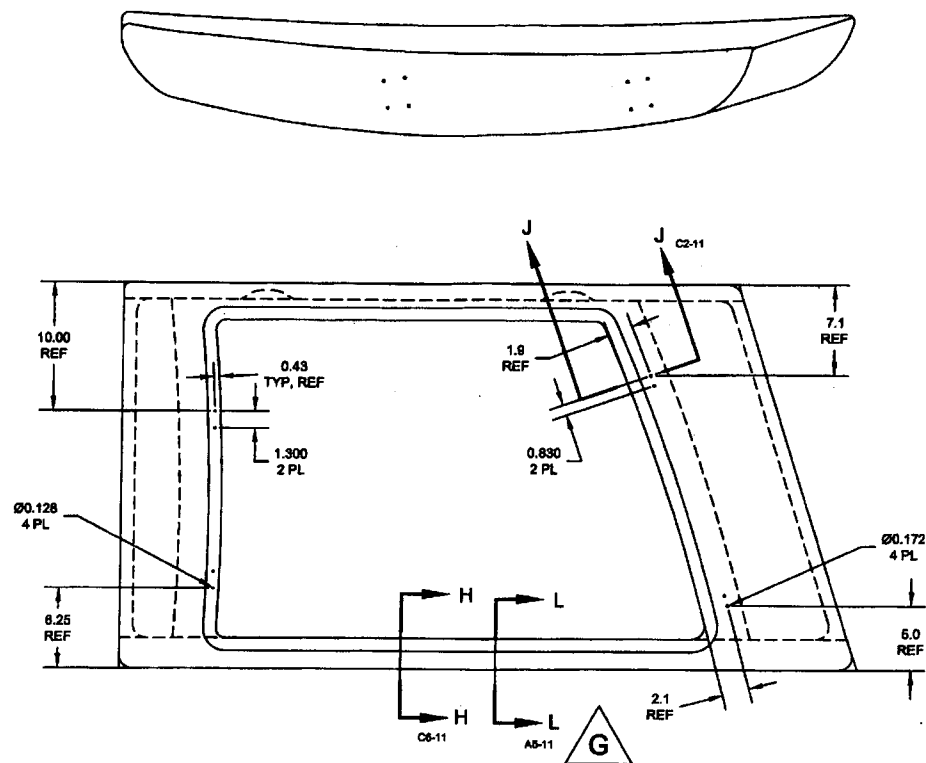
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2014-07-28
wp

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



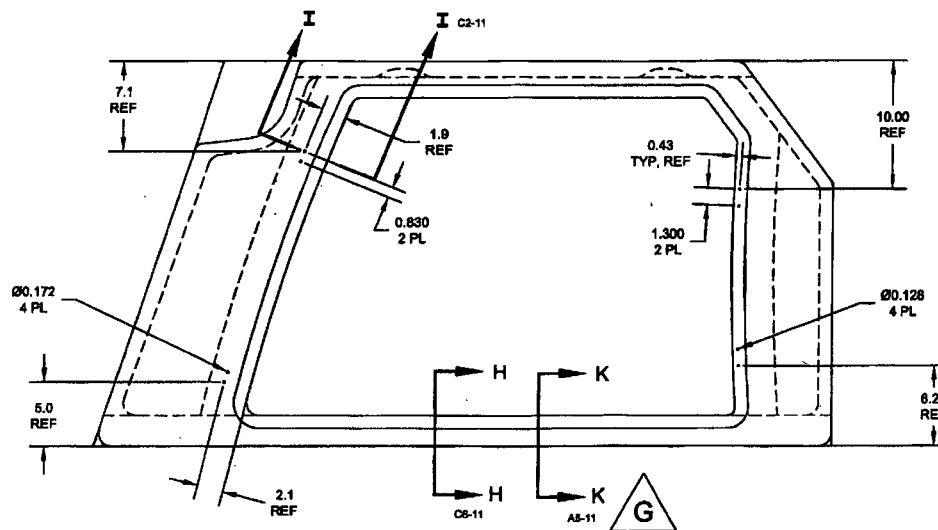
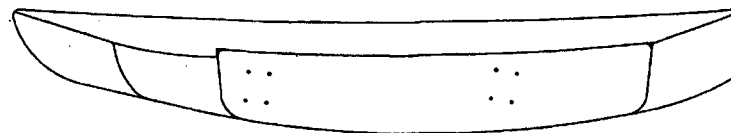
D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS REPRESENTATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



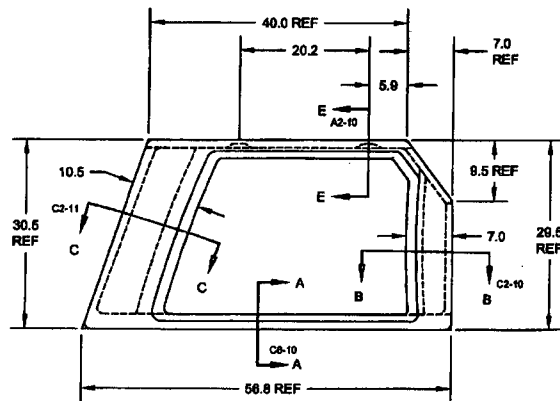
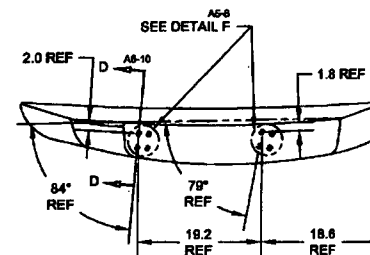
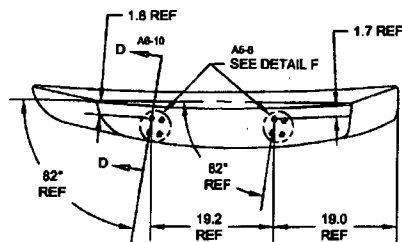
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

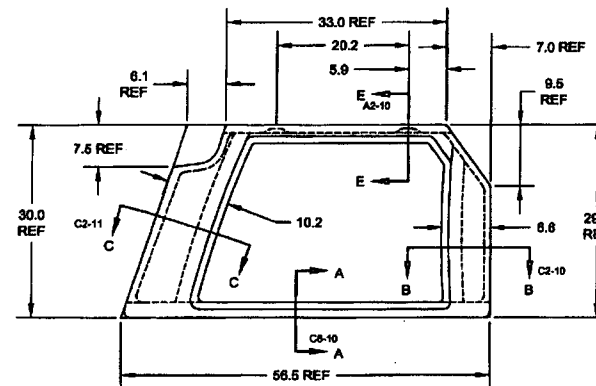
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2014-07-28

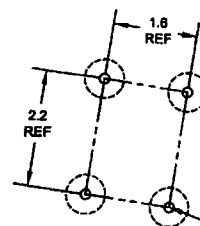
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. G
MFG. APPR.	MP	D3188	SHEET 7 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED BY THE EXPRESS OR IMPLIED WARRANTY THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OPENED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

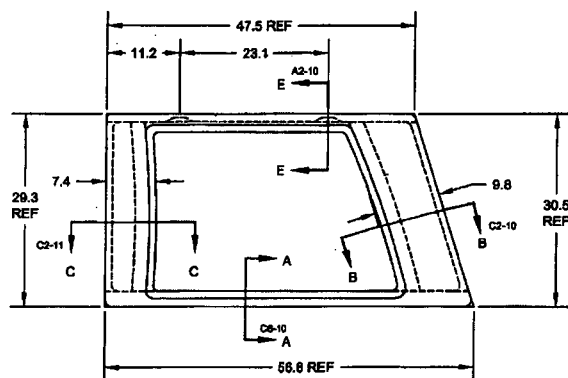
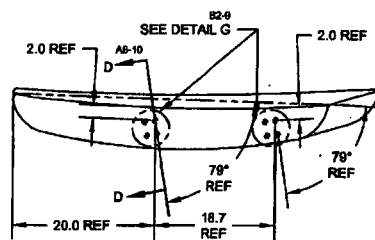
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

RELEASED
2014-07-28

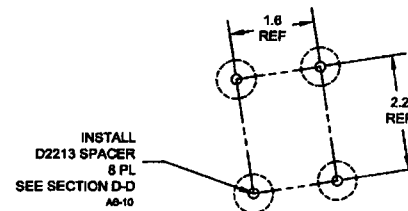
D3188-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED AS CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3188-2M SPACEPOD BODY



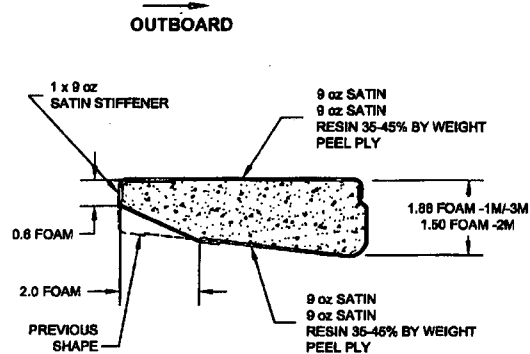
DETAIL G D6-8

RELEASED
2014-07-28

D3188-2M NOTES:

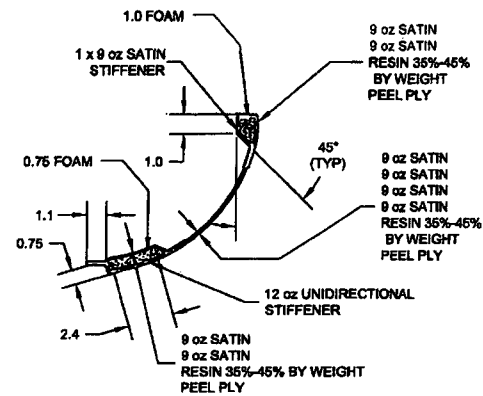
- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



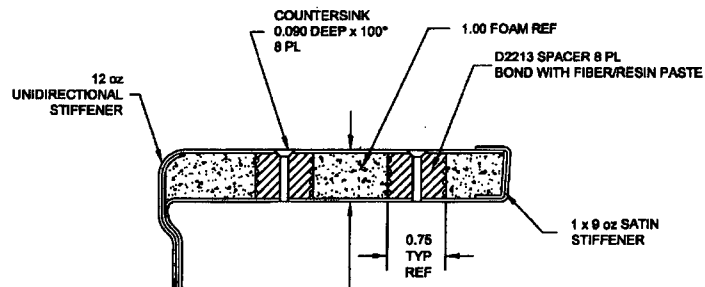
SECTION A-A
TYPICAL FLOOR SECTION

D7-6
D3-6
D9-6



SECTION B-B
SECTION C-C OPPOSITE

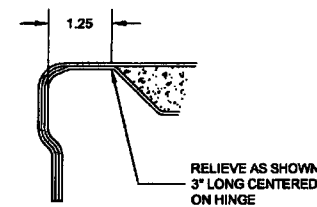
D6-6
D8-6
D4-6
D2-6
D7-6
D5-6



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-6
D7-6
D9-6

9 oz SATIN
9 oz SATIN
18 oz CLOTH
1.00 FOAM
9 oz SATIN
9 oz SATIN
RESIN 35-45% BY WEIGHT
PEEL PLY



SECTION E-E
2 PLACES PER POD

D3-6
D7-6
D9-6

RELEASED
2014-07-28

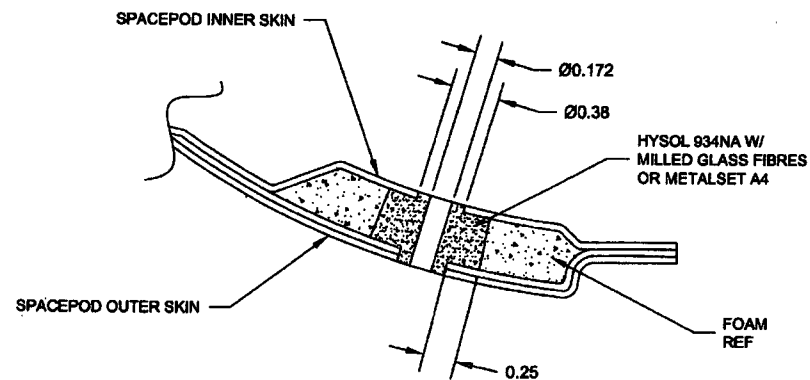
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

OUTBOARD

INSTALL AKS7-1032-130
INSERTS 28 PL
PER D3188-1T1 (D3188-1/3/5/7)
OR D3188-2T1 (D3188-2/6)
TO ALIGN WITH HOLES IN D3187-1/2 FLOORS



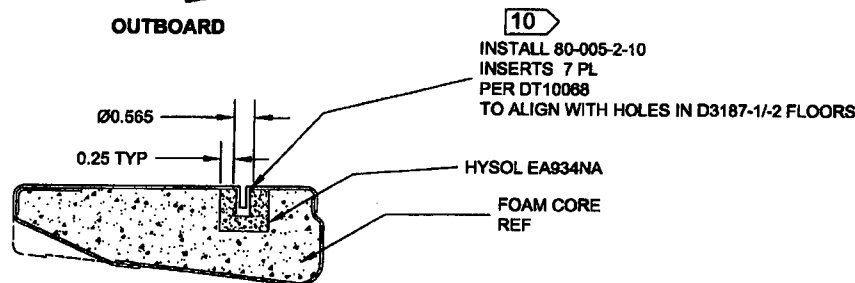
A6-2
A6-3
A6-4
A6-5
B6-6
B6-7



SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C6-6
C4-6
C6-7

OUTBOARD

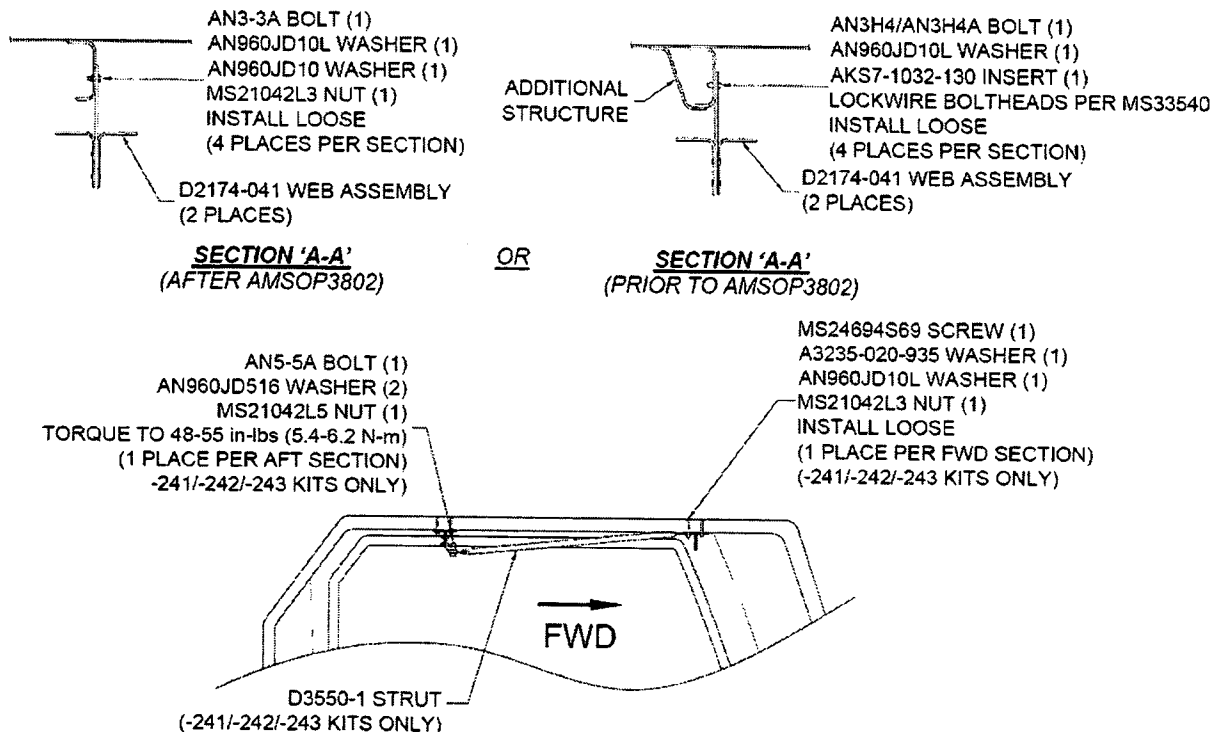


SECTION K-K
SECTION L-L OPPOSITE
TYPICAL FLOOR SECTION

B4-2
B5-3
B4-4
B4-5
B4-6
B4-7

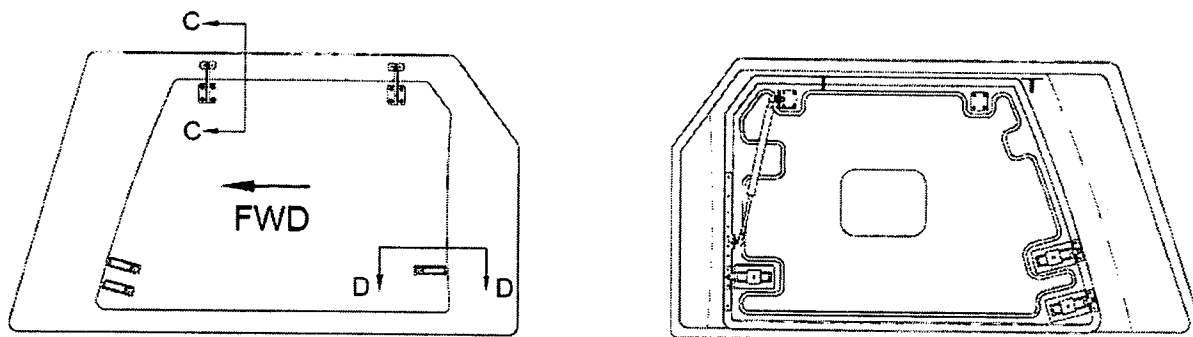
RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**SECTION 'B-B' STRUT INSTALLATION**

3.2.10 Tighten the floor and web assembly fasteners. Torque to 15-25 in-lbs.

3.2.11 Re-install the D3186-1/-2/-3/-4 *Spacepod™* door by connecting the hinges as shown Figure 6. Install the D3552-7/-3 gas spring rod end down on the ball studs. Ensure that the latches are closing the door tightly and securely; adjust the latches as necessary as shown in Figure 6.



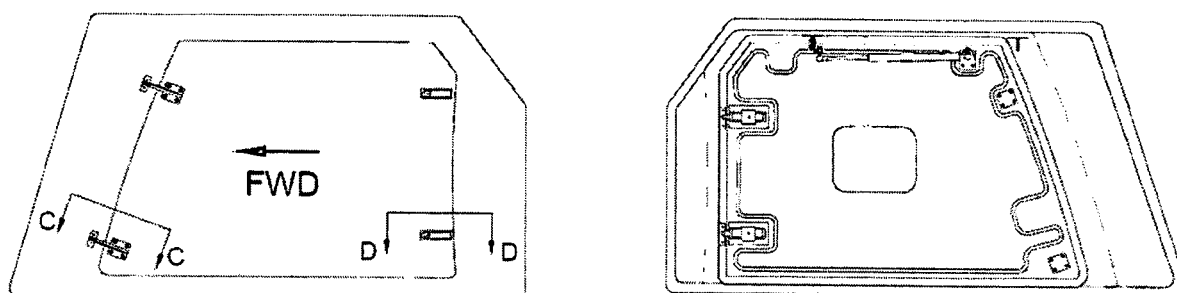
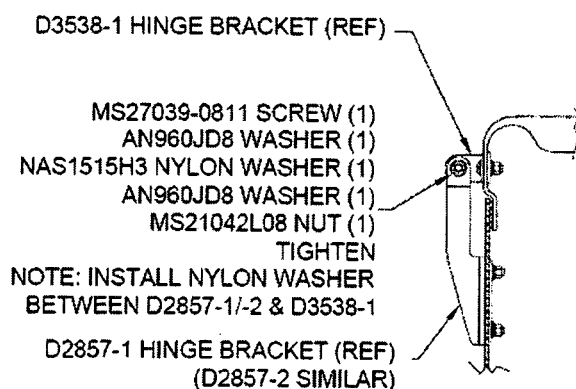
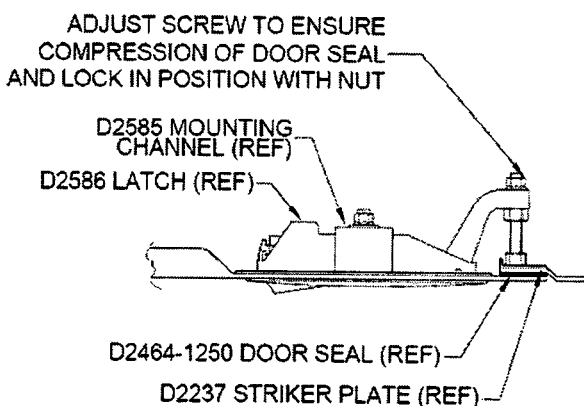


FIGURE 6(b) – -241 SPACEPOD™ KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE

(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
 - a. Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
 - b. If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
 - c. Re-install the belly panel per the Aircraft Maintenance Manual.
- 3.2.13 Relocate the forward door-open switch using the D350-600-349/-449 Door Switch Relocation Kit in accordance with Section 3.6 of this IIN.
- 3.2.14 Re-install the cargo restraining system per Section 4.0 of this IIN.
- 3.2.15 Complete any other maintenance required prior to returning to service.
- 3.2.16 Install the D2985 decal on a clearly visible area of the instrument panel.

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV 5**

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY and SR00099NY
REF. EASA STC EASA.IM.R.S.01292

1.0 PURPOSE

In response to customer feedback, Dart is implementing changes designed to ease the mounting of hinge brackets for the forward opening Spacepod and to improve the security of the hinge assemblies. The purpose of this DSI is to introduce the DSI 9701-011 Hinge Shim Kit and to provide instructions and parts lists to install and assemble the hinges on Dart Spacepods D350-600-241/-242/-243/-247/-248/-249. One Kit is required per door.

2.0 PROCEDURE

- 2.1 Remove the D3186-3/-4 Spacepod Door by disconnecting the hinges.
- 2.2 Remove the D3538-1 Hinge Brackets and D2179 Hinge Bracket Plates. Retain all parts.
- 2.3 Re-install the D3538-1 Hinge Brackets with the D5127-3 Shims between the Spacepod and Hinge Bracket using the existing mounting holes and fasteners. See Figure 1. The D3538-1 Hinge Brackets should be oriented as per Table 1. It may be necessary to reverse the orientation, as required, on some Spacepod bodies. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.4 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).

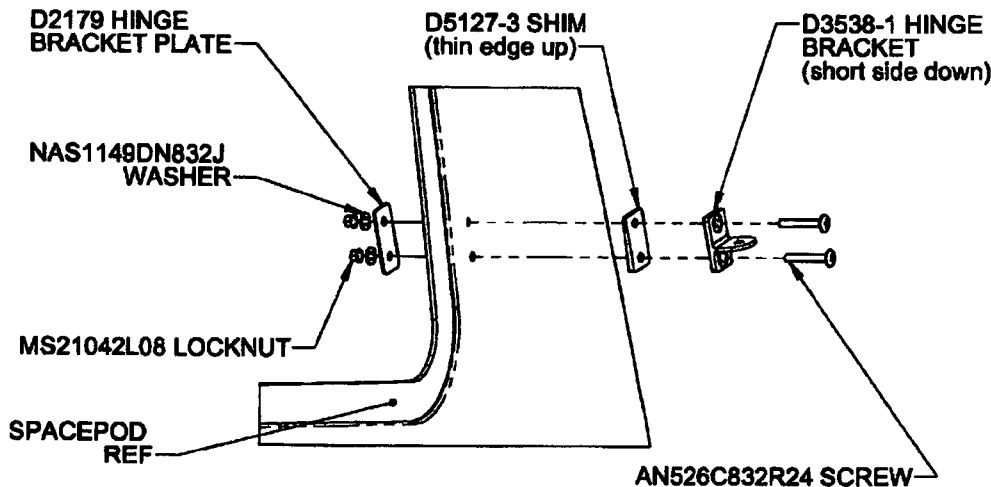


FIGURE 1: SPACEPOD HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

SPACEPOD	UPPER D3538-1 BRACKET	LOWER D3538-1 BRACKET
RIGHT SIDE	SHORT SIDE UP	SHORT SIDE DOWN
LEFT SIDE	SHORT SIDE DOWN	SHORT SIDE UP

TABLE 1: D3538-1 HINGE ORIENTATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

B	ADD NOTES ALLOWING USE OF ADDITIONAL SHIM MATERIALS, ALTERNATE SHIM ORIENTATION	DB	14.09.09
A	NEW ISSUE	DB	14.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9701 TITLE HINGE SHIM KIT REV. B SHEET 1 OF 3 SCALE NTS	
DRAWN	DB		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	N/A		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	14.09.09		

COPYRIGHT © 2014 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

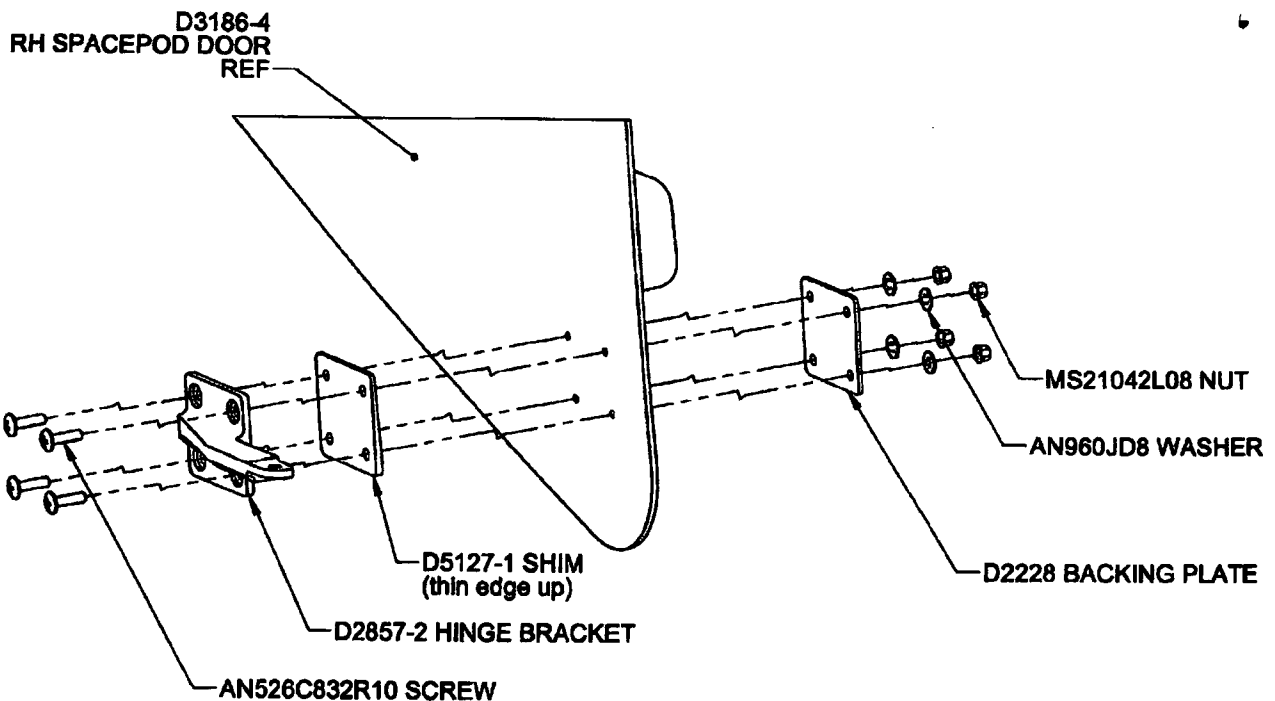


FIGURE 2: SPACEPOD DOOR HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

- 2.5 Remove the D2857-1/2 Hinge Brackets and D2228 Backing Plates. Retain all parts and fasteners.
- 2.6 Re-install the D2857-1/2 Hinge Brackets with the D5127-1 Shim between the Spacepod Door and Hinge Brackets, using the existing mounting holes and fasteners. See Figure 2. The hinge brackets should be installed as shown in Table 2. Shims can be re-oriented, as required, to provide the best mounting configuration. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.7 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).
- 2.8 Re-install the D3186-3/4 Spacepod Door onto the Spacepod per Section 52.4 of ICA-D350-600. See Figure 3 for reference.

DOOR	UPPER HINGE BRACKET	LOWER HINGE BRACKET
RIGHT SIDE	D2857-1	D2857-2
LEFT SIDE	D2857-2	D2857-1

TABLE 2: HINGE SELECTION CHART

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-86
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9701	REV. B
MFG. APPR.	N/A	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE HINGE SHIM KIT	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	14.09.09		

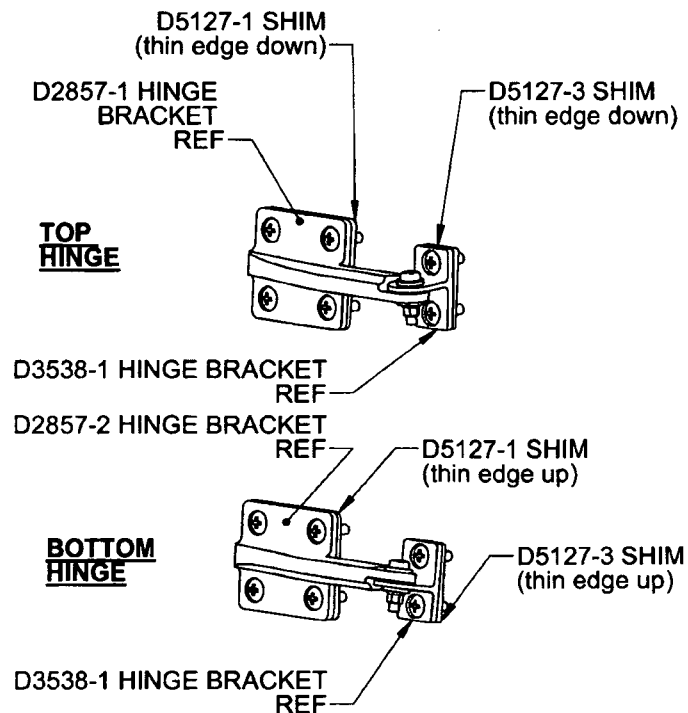


FIGURE 3: DSI 9701-011 HINGE KIT ASSY
(RH DOOR ASSY SHOWN, LH OPPOSITE)

3.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9701-011	HINGE SHIM KIT
2	D5127-1	SHIM, LARGE
2	D5127-3	SHIM, SMALL

4.0 WEIGHT AND BALANCE

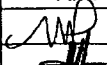
There is no Weight and Balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO. DSI 9701	REV. B
MFG. APPR.	N/A		SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE SHIM KIT	NTS
DATE	14.09.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	